

Work Order ID 83508

83508

Page 1

Thursday, April 19, 2012 10:24:54 AM

Item ID: D3319-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 4/19/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 4/27/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Q Date: 12-04-19 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3319	C								

100
 100
 Waterjet
 FLOW CNC Waterjet
 1010 . 050
 FLOW WATER JET
 Memo
 1-Cut as per Dwg D3319
 Dwg Rev: C
 Prog Rev: C
 2-Deburr if necessary

110
 110
 QC
 Quality Control
 QC2- Inspect parts off machine FAI/FAIB
 Memo

6 0 Jm12
12-5-14
6 0 Jm12
12-5-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Quality Control

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/19/2012 **Start Qty:** 6.00

6

Required Date: 4/27/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

160

Large Fab

0.00

Large Fab

Memo

Large Fab

Weld hard surface using D3319-5T2 per QSI 004 and Dwg D3319
Batch A/R 7560 Hardcoat Rod *m119712*

M119712

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

0.004

QC

Memo

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

0.00

OC

Memo

Quality Control

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Revision ID:

Stop ***NS2***

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Start Date: 4/19/2012 Start Qty: 6.00

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

190

Powdercoat

Powder Coating

Memo

START TIME: 8:00OVEN TEMPERATURE: 320 °FFINISH TIME: 8:30

6X

Ø

ML
12/05/22

200

QC3- Inspect Part Finish

0.00

200

QC

Quality Control

Memo

0.00

6 Ø

BL 12-5-22

210

Packaging

0.00

210

Packaging

Packaging

Memo

0.00

Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-5, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock

Location: SI 496

6x

SP
12-5-22

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6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/5/22

CME
12-05-22

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Picklist Print

Thursday, April 19, 2012 10:24:57 AM

Page 1

Work Order ID: 83508

83508

Parent Item: D3319-5

D3319-5

Parent Item Name: Wearplate

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A05.05.11New issue KJ/JLM
IPP Rev:B Now On Waterjet 06-08-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA		Purchased		No		100	sf	46.2960	0.656	4.143158			

M1010S18GA

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT019

46.296

116268

3

117806

43.296

~~117806~~
117806

Jm101
12-5-14

Dart Aerospace Ltd

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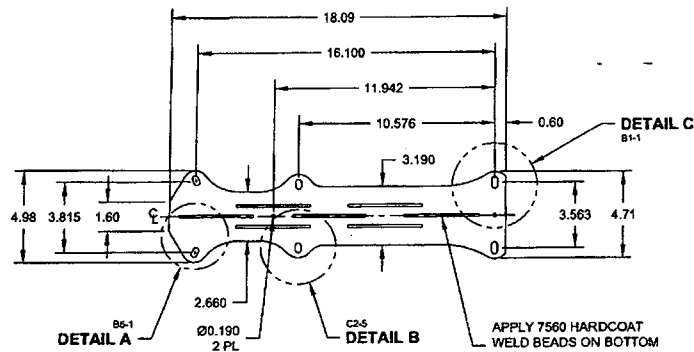
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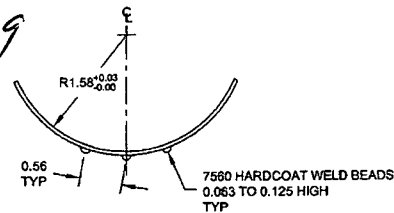
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83508

12 04-19

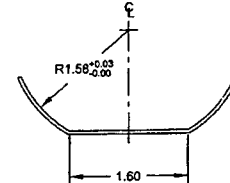


APPLY 7560 HARDCOAT
WELD BEADS ON BOTTOM
SURFACE AFTER FORMING
SEE SECTION D-D
A8-5

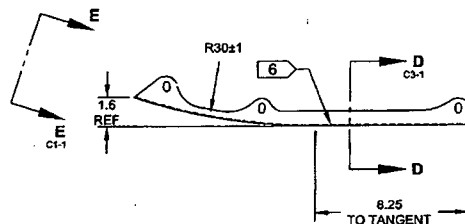
D3319-1F FLAT PATTERN



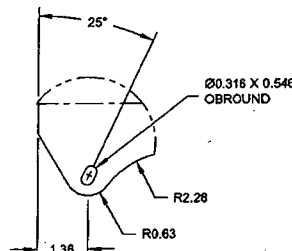
SECTION D-D
SCALE 4X



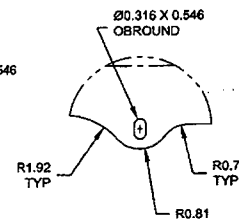
SECTION E-E
SCALE 4X



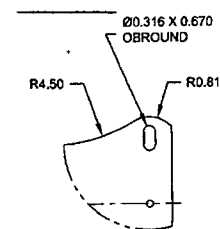
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-546 12.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/-5/-7 (REF DETAIL G); SEE NCR12-547.	MB	12.03.13
B	WIDEN HOLES, REDUCE WIDTH ON -3/-5/-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	WEARPLATE NTS	
DATE	12.03.13	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

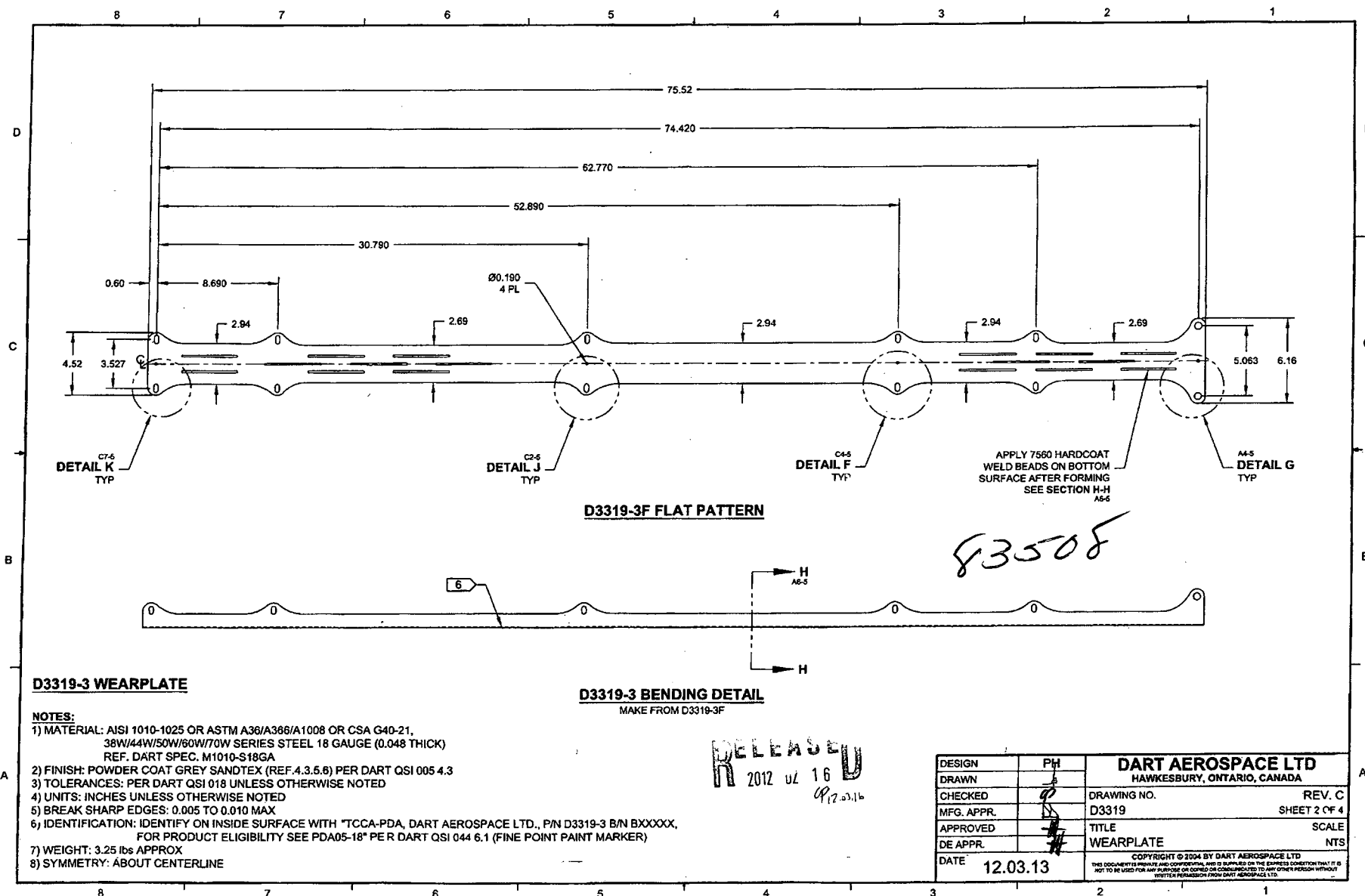
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



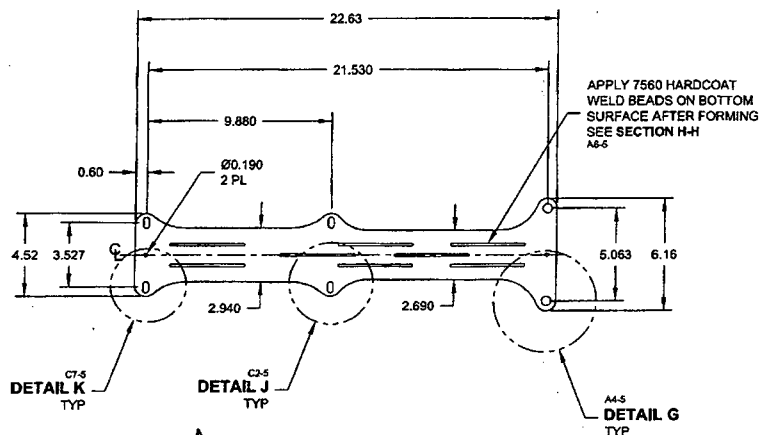
W/O:		WORK ORDER CHANGES					
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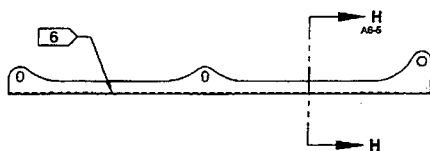
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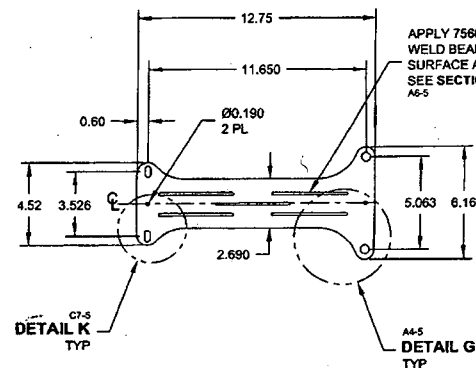
NOTE: Date & initial all entries



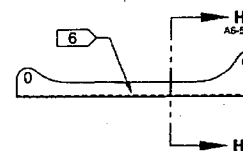
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

53505

D3319-5/-7 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21.
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16

912.0316

DESIGN	PH	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3319	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
DATE	12.03.13	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS A SERVICE AND COURTESY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

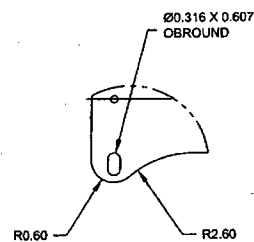
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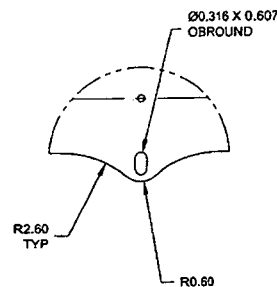
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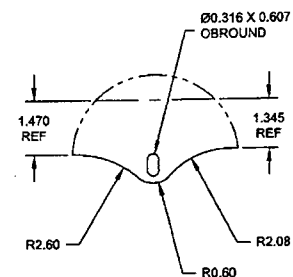
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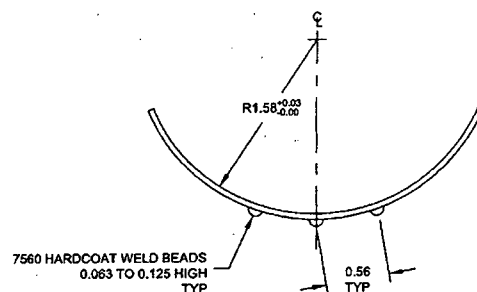
DETAIL K
SCALE 2X
B8-2
C4-3
C8-3



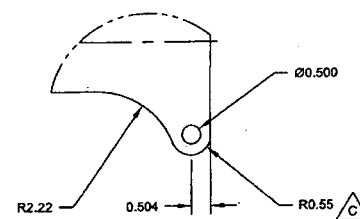
DETAIL F
SCALE 2X
B8-2



DETAIL J
SCALE 2X
B8-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B8-2
C2-3
C8-3

83508

RELEASED
2012-02-16
912-0316

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. C
MFG. APPR.	D	D3319	SHEET 4 OF 4
APPROVED	J	TITLE	SCALE
DE APPR.	J	WEARPLATE	NTS
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